

Date: Thursday, 06/12/2007 10:27:25 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D135-751-011 REWORK

Job Number : 36165

Estimate Number : 10804

P.O. Number : N/A

Part Number : D135751011

This Issue : 06/12/2007 S.O. No. : N/A

Drawing Number : ECN1036

Prsht Rev. : NC

Project Number : N/A

First Issue : N/A Type : LANDING GEAR

Drawing Revision : N/A

Previous Run : 36164

Material : N/A

Due Date : 13/12/2007

Written By : _____

Checked & Approved By : _____

Comment : _____



1 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D135-751-011 B28954

2.0

D135751011

SKIDTUBE INSTALLATION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE INSTALLATION

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REMOVE 1 X D3508-7 REV.B WEARPLATE

REMOVE 2 X D3512-1 REV.B WEARPLATE

SCRAP BOTH

REWORK SKID PER DRWG IAW D3507 REV.C

(DRILLING DETAIL HAS CHANGED)

DD
7-12-6

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 7/12/07 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/12/2007 10:27:25 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D135-751-011 REWORK

Job Number: 36165

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

ALUMINUM ROD m105138

WELD 2 X D3504-5 CROSSBOLT SPACERS
PER DRWG D3507 REV.C

BE 07-12-13

6.0

D35045

CROSSBOLT SPACER



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)
CROSSBOLT SPACER

R36181 BE 07-12-13

7.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

QC6 5/21/14 (X)

QC9 11/07/12/14

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M105914

(1X)

REMOVE ALL EXISTING PARTS:
WEARPLATES, CAPS, INSERTS, BOLTS, WASHERS
KEEP EXISTING WEARPLATES & CAPS
DISCARD INSERTS, BOLTS & WASHERS

M-1/07/12/17

M/A
07-12-12
MASK D3506-1/-3 DOUBLER, PLUG HOLES
RE-POWDER COAT PER QSI005
(STRIP IF NECESSARY)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-12-17

10.0

ALS41032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)
Insert

07-12-17

07-12-17

0.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/12/2007 10:27:25 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D135-751-011 REWORK

Job Number: 36165

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

ALS41032225

Insert



NOT
REQ'D



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Insert

07-12-17

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

RE-ASSEMBLE CAPS (SIKAFLEX) B M105585 EXPIRE DATE 08-07
& WEARPLATES
PER DRWG D3507 REV.C

PICK NEW 1 X D3508-7 REV.C B 36179
INSTALL PER DRWG D3507 REV.C

PICK 4 X D3492-043 PLUGS B 35840
INSTALL PER DRWG D3507 REV.C

Wing work B106332 m-1 07/12/17

13.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
PLUG ASSEMBLY B 35840

BR

14.0

D35087

WEARPLATE



* 13558-7
ADD GASKET - DB.30001



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARPLATE B 35840 36179

BR

15.0

AN3C4A

BOLT



Comment: Qty.: 31.0000 Each(s)/Unit Total: 31.0000 Each(s)
BOLT M 106431

BR

16.0

AN960C10L

washer



Comment: Qty.: 33.0000 Each(s)/Unit Total: 33.0000 Each(s)
washer M 106302

BR

* ADD GASKET. D3558-1 DB 29998. BR

BR 07-12-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/12/2007 10:27:25 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D135-751-011 REWORK

Job Number: 36165

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN3CSA

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt

M 106352

BR

18.0

AN526C1032R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Screw

M 15072

BR

07-12-17

(1)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/18

(H)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
ENSURE ORIGINAL KIT IS INCLUDED
ADD:

2 X D3512-1 **REV.C** WEARPLATE B

36180

AS 07/12/19

(X1)

21.0

D35121

WEARPLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
WEARPLATE

B 36180

B 36180

AS 07/12/19

(X1)

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/12/21

(X1)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PACKAGE PER PPP
USING NEW B/N - CHG 001

PPPP

07/12/21

36165

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/12/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/12/2007 10:27:26 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D135-751-011 REWORK

Job Number: 36165

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
D07/12/27

Job Completion



W 07.12.24

POSITIVE RECALL

EFFECTIVE 07.12.14 AUTH W

RELEASED 07.12.14 DATE W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AEIS-1032-130	INSERT
1	AEIS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING
D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3 5.1) PER DART
QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER
DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER
DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8889 TO LOCATE AND DRILL Ø0.297 HOLES (38
PLACES) FOR WEARSHOE INSERTS. INSTALL AEIS-1032-130 PER SECTION C-C (38
PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED
LOCATIONS

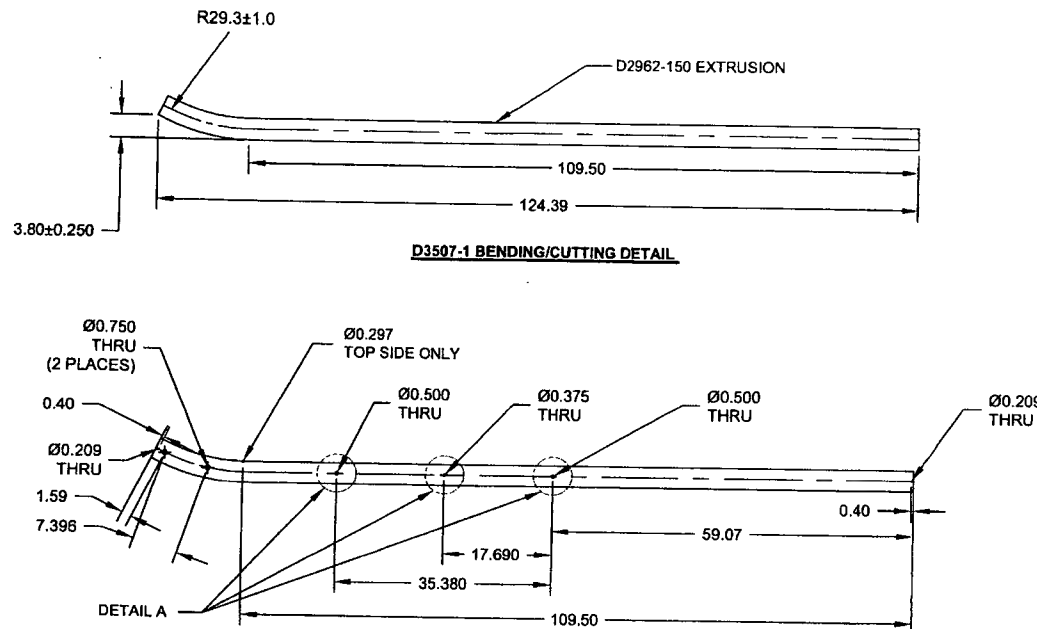
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PC		
CHECKED	BA		
MFG. APPR.	GP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.09.19		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

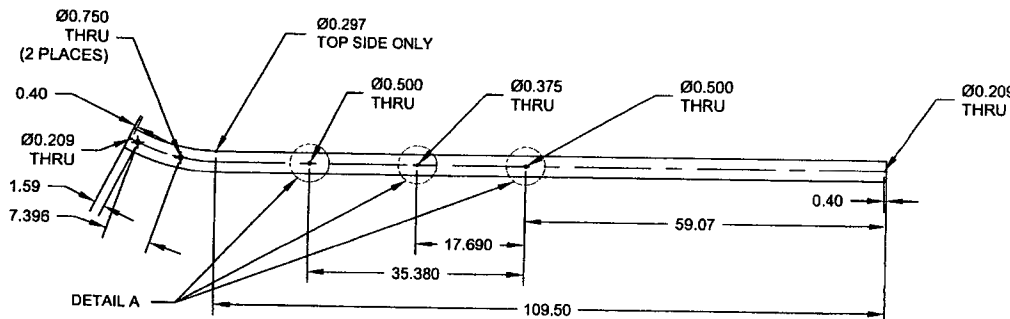
DRAWING NO. D3507
REV. C
SHEET 1 OF 2

TITLE
SCALE
EC 135 SKIDTUBE
NTS

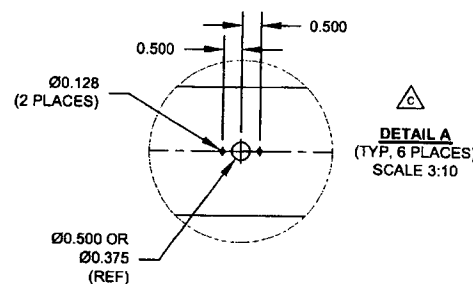
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D3507-1 BENDING/CUTTING DETAIL

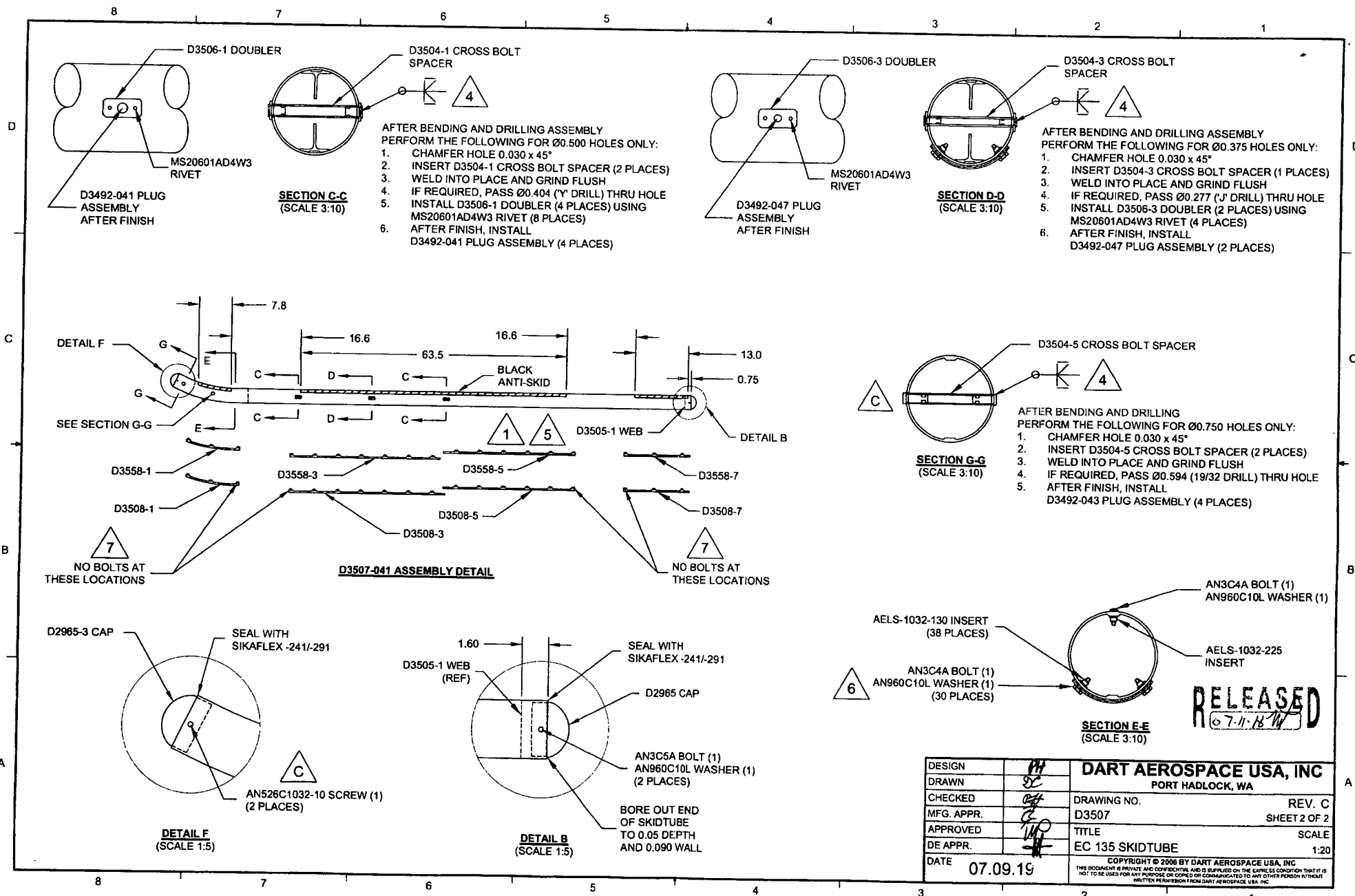


D3507-1 DRILLING DETAIL



DETAIL A
(TYP. 6 PLACES)
SCALE 3:10

*W/B
36665*



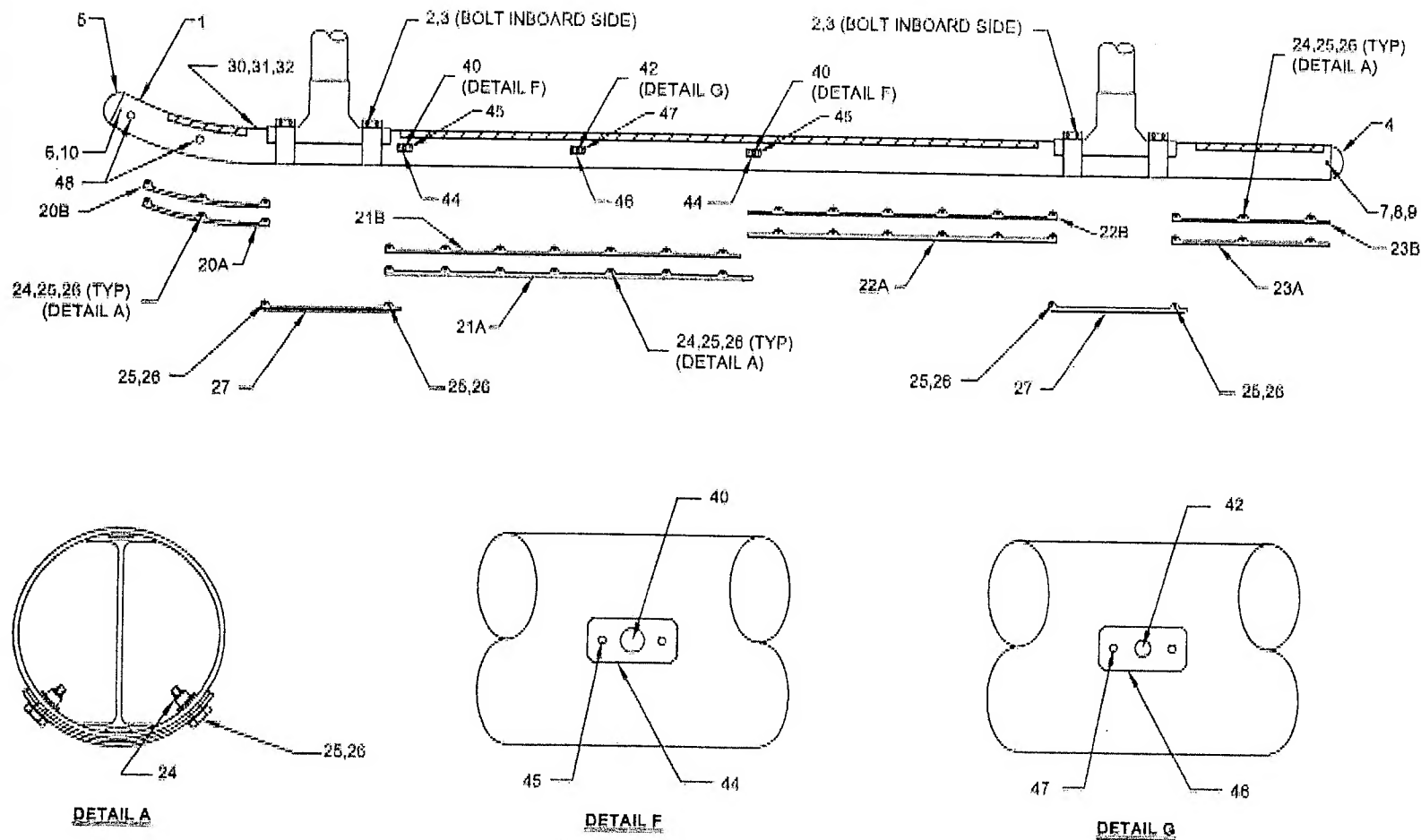


FIGURE 2 - D135-751-011 SKIDTUBE INSTALLATION

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Revision: C

Date: 07.09.20

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D135-751

Job Number : 36712

Estimate Number : 10804

P.O. Number : N/A

This Issue : 11/01/2008 S.O. No. : NA

Prsht Rev. : NC

First Issue : NA Type : LANDING GEAR

Previous Run : 00015

Part Number : Z_CUSTOM

Drawing Number : ECN 1104

Project Number : N/A

Drawing Revision : N/A

Material : N/A

Due Date : 18/01/2008

Qty: 1 Um: Each

Written By : _____

Checked & Approved By : _____

Comment : _____

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STK:

2 X D135-751-011 B

ADD NEW PAPERWORK TO KITS
PER ECN 1104

RETURN TO STK

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CA 08-11-14

Date: Thursday, 02/10/2008 2:26:30 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	UPDATE PAPERWORK D135-751-011/041/043/101	
Job Number :	42424			
Estimate Number :	10804			
P.O. Number :		Part Number :	ECN10	
This Issue :	02/10/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	ECN08-544	
First Issue :	11	Project Number :		
Previous Run :	00015	Drawing Revision :		
		Material :		
Written By :		Due Date :	02/10/2008	Qty: 1 Um: Each
Checked & Approved By :	<u>MF 08-10-02</u>			
Comment :				

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK D135-751-011 B 36165 X QTY1
 B 36167 X QTY1

UPDATE PAPERWORK : RELEASE FAA STC SR01709SE
 PER ECN08-544

RETURN TO STOCK

8/10/02

rx 5d

2.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

08/10/03

Job Completion



u 811003